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April 16
D205-634-041
Job Sheet 175169



Part No: D205-634-041

Job Qty: 1 ea

Part Name: Replacement Skidtube with Standard Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/28/18

Job Tracking No:

Due Date: 4/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D2580 REV H SHEETS 1,2,3,8 IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD IPP Rev. O 06.02.28 Added paperwork EC IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q 10.12.01 as per chg003 DD ver:EC IPP REV:R 12.01.23 AS PER ECN11-684 VERF:EC IPP REV:S 17.12.08 REMOVE GASKET AS PER INTUITIVE INFO DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		4/13/18	0.00	0.00	Start Up Skidtubes		<i>MB</i>
110	CNC Bend Skidtubes	1 pcs		4/13/18	0.00	0.65	CNC Bend Skidtube		<i>LMG/LS JH</i>
120	Skidtubes	1 pcs		4/14/18	0.00	2.89	Skidtubes-2		<i>DO</i>
130	QC	1 pcs		4/14/18	0.00	0.00	QC5		<i>BE</i>
140	Skidtubes	1 pcs		4/14/18	0.00	2.89	Skidtubes-2		<i>MB</i>
150	QC	1 pcs		4/14/18	0.00	0.00	QC10		<i>38</i>
160	QC	1 pcs		4/14/18	0.00	0.00	QC5		<i>9-89 38</i>
170	HandFinish	1 pcs		4/14/18	0.00	1.31	HandFinish2		<i>SA 18-5-23</i>
180	Powdercoat	1 pcs		4/14/18	0.00	0.34	Powdercoat1		<i>18-5-26</i>
190	QC	1 pcs		4/14/18	0.00	0.00	QC3		<i>18-5-28</i>
200	HandFinish	1 pcs		4/16/18	0.00	1.31	HandFinish4		<i>18-5-28</i>
210	QC	1 pcs		4/16/18	0.00	0.00	QC5		<i>38</i>
215	DC	1 pcs		4/16/18	0.00	0.00	DC		<i>9-89</i>
220	Packaging	1 pcs		4/16/18	0.00	0.00	Packaging3-1		<i>7.11</i>
230	QC21-FG	1 Ea		4/16/18	0.00	0.00	QC21		<i>MAY 30 2018</i>

Part Op 110 - 1-Bend as per program D2580.C on CNC Bender and Folio 16 2-Cut tubes as per Dwg. D2580 3- scribe batch# in Descriptions: aft end of tube

120 - 1- Deburr ends and remove bending marks 2- Prepare tube for welding as per QSI 004

140 - 1-Weld step D2576 as per Dwg. D2580 and QSI 004 2-Grind welds on step as per Dwg D2580 3- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x17G to start expansion and finish with 1/2 x 18G to achieve dwg dimention. 4-Drill holes for wearplates using DT 8217 & DT8937, 7.40" from most fwd saddle holes (ref only) Open holes to 19/64", adjust stopper not to hit web.Deburr 6-Drill pilot holes for aft cap using DT 8215Open holes to 0.208". Deburr 7-Drill pilot holes for Tow ring using DT8091, open to .640"and Deburr

170 - Re-alodine tubes as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

180 - START TIME: *8:10* OVEN TEMPERATURE: *320°* FINISH TIME: *8:40*

200 - 1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates A/R Sikaflex-291 _____ Sikaflex expire date: _____ 2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580 3-Inspect for foreign object per QSI 024 4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive A/R Sikaflex-291 _____ Sikaflex expire date: _____

5-Wing Walk as per Dwg D2580 and QSI 005 4.4 Batch: _____

210 - Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

003454

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2580-1	205 Bent Tube	1 Ea (1 ea)	90-Start up Operation	5061525
D2576-3	Step (Machining Detail)	1 Ea (1 ea)	140-Skidtubes	5064014
D4202-1	Spacer	20 Ea (20 ea)	140-Skidtubes	5054571
ALS7-1032-130	Rivnut	50 Ea (50 ea)	200-HandFinish	5045668
AN3-5A	Bolt	2 Ea (2 ea)	200-HandFinish	5041106-1
AN3C4A	Bolt	50 Ea (50 ea)	200-HandFinish	5041114
D2594-1	Plug	16 Ea (16 ea)	200-HandFinish	5059021
D2594-3	O-Ring	16 Ea (16 ea)	200-HandFinish	5049877
D2855	Cap	1 Ea (1 ea)	200-HandFinish	F147805
D3564-11	Wearplate Aft	1 Ea (1 ea)	200-HandFinish	5054591
D3564-13	Wearpad Fwd	1 Ea (1 ea)	200-HandFinish	5054456
D3564-5	Wearplate Center	1 Ea (1 ea)	200-HandFinish	5054590
D3564-9	Wearplate Fwd	1 Ea (1 ea)	200-HandFinish	5054592
NAS1149C0332R	Washer	50 Ea (50 ea)	200-HandFinish	5044236
NAS1149D0332J	Washer	2 Ea (2 ea)	200-HandFinish	5070606-1

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2580-1	1	13	0
140-Skidtubes	D2576-3	1	19	0
	D4202-1	20	948	0
200-HandFinish	ALS7-1032-130	50	3,000	0
	AN3-5A	2	430	0
	AN3C4A	50	2,355	0
	D2594-1	16	588	0
	D2594-3	16	1,157	0
	D2855	1	43	0
	D3564-11	1	43	0
	D3564-13	1	37	0
	D3564-5	1	34	0
	D3564-9	1	40	0
	NAS1149C0332R	50	4,574	0
	NAS1149D0332J	2	3,396	0

Part Specifications

se.marie

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UART
AEROSPACE

Container No: S069620



Part: D205-634-041

Job No: 175169

Serial No/Batch: S069620

Revision: H

Inspector:

Date: 05/09/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					